

November 18, 2015 10:28:29 AM

139249

Page 1

Item ID:	D4542-5	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:						
Item Name:	Retainer, Inner				Stop	*NS2*
Start Date:	11/17/2015	Start Qty: 14.00	*14*	Cust Item ID:		
Required Date:	12/4/2015	Req'd Qty: 14.00	*14*	Customer:		
Reference:						

Approvals: _____ 20151118 _____ Run Start *NR1*
 Process Plan: SM _____ Date: _____ Tooling: _____ Date: _____ Stop
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ *NR2*

[illegible]

DQA:

Aut

Date:

16/01/15

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☒

Work Order: <u>139249</u> Part No. <u>D4542-5</u> NCR No.		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☒</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☒	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Work Order ID 139249

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139249

Page 2

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Revision ID: **Stop *NS2***
Item Name: Retainer, Inner
Start Date: 11/17/2015 **Start Qty:** 14.00 ***14*** **Cust Item ID:**
Required Date: 12/4/2015 **Req'd Qty:** 14.00 ***14*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				13	1		38 9-89
120									
QC	Memo	0.00							
Quality Control									DEC 17 2015
125	Chemical Conversion Coat per QSI005 4.1	0.00							
125									
HandFinish	Memo	0.01							
Hand Finishing									13 DP 15-12-3
127	QC7-Inspect Chemical Conversion Coat	0.00							
127									
QC	Memo	0.00							
Quality Control									13 DAS 38 9-89 DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Revision ID: **Stop** ***NS2***
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Required Date: 12/4/2015 **Req'd Qty:** 14.00 ***14*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St631</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

13 **DEC 07 2015**
DEC 08 2015
DEC 08 2015
DEC 07 2015
DEC 07 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

Picklist Print

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Work Order ID: 139249

139249

Parent Item: D4542-5

D4542-5

Parent Item Name: Retainer, Inner

Start Date: 11/17/2015

Required Date: 12/4/2015

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B
12.02.24 as per dwg revA DD verf:EC IPP REV:C 12.05.08 as
per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg revD
DD verf:JLM IPP REV:E 15.01.06 AS PER DWG REV.F DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	185.7000	0.208	3.065263			

M6061T6S 032

6061-T6 Sheet 0.032"

02/15/12/01

Location

Loc Qty

Loc Code

MAT021

185.7

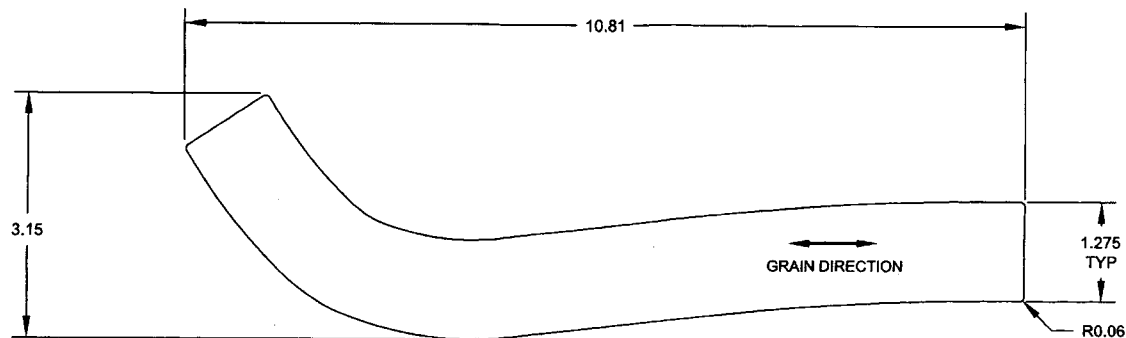
m131352

53.6

m132772

132.1

3



D4542-5 RETAINER, INNER
(TOP CORNER)

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REV.F.DXF"

RELEASED
2015-01-05

20151118

139249 SH

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. F
CHECKED		D4542	SHEET 4 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		RETAINER, INNER	NTS
DE APPR.			
DATE	14.04.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS loaned ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	